

Work Order ID 153263

Tuesday, November 15, 2016 11:17:46 AM

153263

PRELIMINARY ISSUE

Page 1

Item ID: 647.7352

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skid Deflector Assembly

Start Date: 12/15/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/15/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

VS / DAS 21 9-89

Date: 12/10/16

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP 647.7352								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

SHIP DEC 16TH

DEC 16 2016

DAS 21 9-89

1212 16

DAS 27 9-89

DEC 19 2016

DAS 6 9-89

DEC 16 2016

DAS 28 9-89

DEC 16 2016

DAS 27 9-89

DEC 19 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Work Order ID 153263

Tuesday, November 15, 2016 11:17:46 AM

153263

Page 2

Item ID: 647.7352 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skid Deflector Assembly
 Start Date: 12/15/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/15/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00			DAS 27 9-89	DAS 28 9-89			
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP 647.7352 Location : FG109								
									DEC 19 2016
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

DEC 19 2016

DAS
21
9-89

DEC 19 2016

POSITIVE RECALL

EFFECTIVE AUTH

RELEASED DATE

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐		☐	Temperature/Cure ☐	☐	Power Loss/Surge ☐
Design ☐	☐	Operator ☐		☐	Set-up ☐	☐	Folio/Program ☐
Doc/Data ☐	☐	Offset/Setup ☐		☐	BOM/Route ☐	☐	Grain ☐
Equip/Tooling ☐	☐	Supplier ☐		☐	Broken/Damage/Defect ☐	☐	Weld ☐
Handling/Pre ☐	☐	Training ☐		☐	Inspection Incomplete/Unqualified ☐	☐	Wrong Stock Pulled ☐
Material ☐	☐	Use for Testing ☐		☐	Contamination ☐	☐	Out of Sequence ☐
Internal Transport ☐	☐	Poor Information ☐		☐	Countersink ☐	☐	Off-set ☐
Tribal Knowledge ☐	☐	Rushing ☐		☐	Cut Too Short ☐	☐	Mislabeled ☐
LOA ☐	☐	Product Improvement ☐		☐	Instructions Incomplete/Unclear ☐	☐	Fit/Function ☐
Substation ☐	☐	Process Improvement ☐		☐	Drill Holes ☐	☐	Misaligned/off center ☐
Past Expiry Date ☐	☐	Manufacturing Process ☐		OTHER :			
Misidentified ☐	☐	Past Due ☐					

Picklist Print

Tuesday, November 15, 2016 11:17:46 AM

Page 1

Work Order ID: 153263

153263

Parent Item: 647.7352

647 7352

Parent Item Name: Skid Deflector Assembly

Start Date: 12/15/2016

Required Date: 12/15/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 16.09.28 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.1702 *647 1702* Skid Deflector Assembly		Manufactured	No				Each	0.0000		2		DEC 16 2016	
LN9025-0820K *I N9025-0820K* Lock Tab Washer		Purchased	No				Each	0.0000		8		DEC 16 2016	
LN9037-08018 *I N9037-08018* Screw		Purchased	No				Each	0.0000		8		DEC 16 2016	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Description Work Order Deviation				Disposition																																																													
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																



SUBJECT:
Manufacturing Process Procedure
EC-135 CCK Configuration Management

DOCUMENT NO:
MPP-195
Rev. N/C
12/15/16

Table 16: T1/P1 Skid Deflector (SD) Assembly, 647.7351

FIND #	PART #	DESCRIPTION	QTY
3	647.1701	SKID DEFLECTOR ASSY	2
33	647.2510	SLEEVE	4
34	647.2511	NUT	4
51	601.3002	BOLT	4
54	601.3209	LOCKNUT	4
95	601.1097	WASHER	8

Table 17: T2/P2/T3/P3 SD Assembly, 647.7352

FIND #	PART #	DESCRIPTION	QTY
105	647.1702	SKID DEFLECTOR ASSY	2
106	601.3655	LOCK WASHER	8
107	601.3654	BOLT	8

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 153263
[Signature]

DEC 16 2016

Work Order ID 153263

Friday, December 16, 2016 10:20:54 AM

153263

Page 1

Item ID: 647.7352

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: EC135 T2/P2/T3/P3 Skid Deflector Assembly

Start Date: 12/15/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/15/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

MPP-195

REV N/C

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP 647.7352

DAS
21
9-89

DEC 16 2016

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

Marie Lajeunesse

From: Kim Johnston
Sent: Friday, December 16, 2016 9:51 AM
To: Marie Lajeunesse
Subject: FW: EC135 CCK MPP & IIN corrections

Thanks,

Kim Johnston
*Engineering Clerk
Document Administrator*

DART AEROSPACE
T 1 613 632-5200 > ext. 226
F 1 613 632-9311



From: Sian Willems
Sent: Monday, December 12, 2016 9:21 AM
To: Lisa McMachen <lmcmachen@dartaero.com>; Kim Johnston <kjohnston@dartaero.com>
Subject: RE: EC135 CCK MPP & IIN corrections

Go ahead and load. A corrected version will follow once DaveM makes the updates.

SIAN WILLEMS
Customer Support Manager

DART AEROSPACE
T +1-613-632-3336 > 239
M +1-613-676-0577
F +1-613-632-5146
+1-800-556-4166
www.dartaerospace.com

From: Lisa McMachen
Sent: Monday, December 12, 2016 8:26 AM
To: Kim Johnston <kjohnston@dartaero.com>; Sian Willems <swillems@dartaero.com>
Subject: FW: EC135 CCK MPP & IIN corrections

Hi Sian,
Kim says that the paperwork is not jiving...can we load the attached documents to the website as discussed on Friday? Please see the attached email.

Thanks,
Lisa McMachen

From: Sian Willems
Sent: Monday, December 12, 2016 7:21 AM



REFERENCE ONLY

SUBJECT:
Manufacturing Process Procedure
EC-135 CCK Configuration Management

DOCUMENT NO:
MPP-195
Rev. N/C
12/15/16

Table 16: T1/P1 Skid Deflector (SD) Assembly, 647.7351

FIND #	PART #	DESCRIPTION	QTY
3	647.1701	SKID DEFLECTOR ASSY	2
33	647.2510	SLEEVE	4
34	647.2511	NUT	4
51	601.3002	BOLT	4
54	601.3209	LOCKNUT	4
95	601.1097	WASHER	8

Table 17: T2/P2/T3/P3 SD Assembly, 647.7352

FIND #	PART #	DESCRIPTION	QTY
105	647.1702	SKID DEFLECTOR ASSY	2
106	601.3655	LOCK WASHER	8
107	601.3654	BOLT	8

LN9025-0800K
LN9037-08018